

Work Order ID 67724

Tuesday, March 29, 2011 2:27:09 PM



Page 1

Item ID:	D4005-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fwd Floor Gutter					
Start Date:	3/29/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	4/8/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-30	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4005	A								
100		0.00							
	Waterjet								
FLOW CNC Waterjet									
2024-040									
	Memo	0.00							
	1-Cut as per Dwg (D4005-13)								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC									
Quality Control									
	Memo	0.00							

B11-5-5

3

B11-5-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4005-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Floor Gutter

Start Date: 3/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

S 11/05/09

(3)

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

S 11/05/09

(3)

Brake NC

Bend D4005-13 as per Dwg

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 11/05/09

(3)

Quality Control

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Page 4

Item ID: D4005-041

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Setup Start



Revision ID:

Stop



Item Name: Fwd Floor Gutter

Start Date: 3/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

3x ~~✓~~ M 4/05/16

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M115128

Memo

0.00

Powder Coating

Start Time: 1:30
Oven Temperature: 320°
Finish Time: 2:00

3 BL 11-5-17

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

B ~~✓~~ M 11/05/17

W/O:		WORK ORDER CHANGES					
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Start Date: 3/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 141A

0.00



Packaging

Memo

0.00

Packaging

11/5/19 30

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/20

mf

11-05-19

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 2:27:15 PM

Page 1

Work Order ID: 67724

Parent Item: D4005-041

Parent Item Name: Fwd Floor Gutter



Start Date: 3/29/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040 Purchased No 100 sf 136.5000 0.42 0.884211



2024-T3 .040 sheet

Location	Loc Qty	Loc Code
MAT022	136.5	
112291	2.5	
112331	64	
113162	70	

B11-5-5

(3)

112331

~~112331~~

D4003-13 Manufactured No 141 Each 10.0000 1 2



Fwd Fuel Gutter Line

Location	Loc Qty	Loc Code
ST104	10	
64317	10	

11.05.11

3

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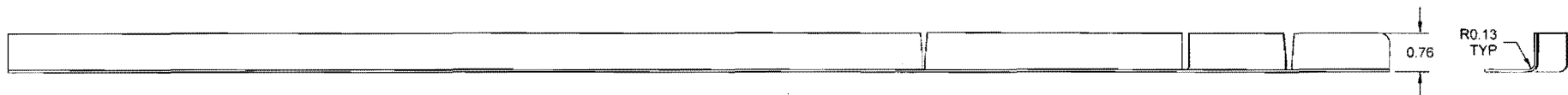
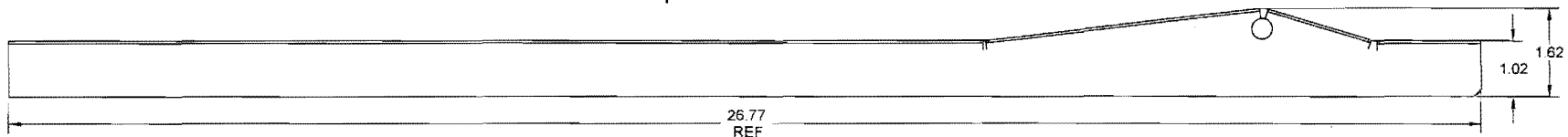
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NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER
D4005-13

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-2-22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67724
PI 11-03-30



D4005-13 ANGLE

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: MADE FROM D4005-13F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D4005	REV. A
DATE	10.02.05	TITLE RESTRAINT	SHEET 14 OF 15 SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

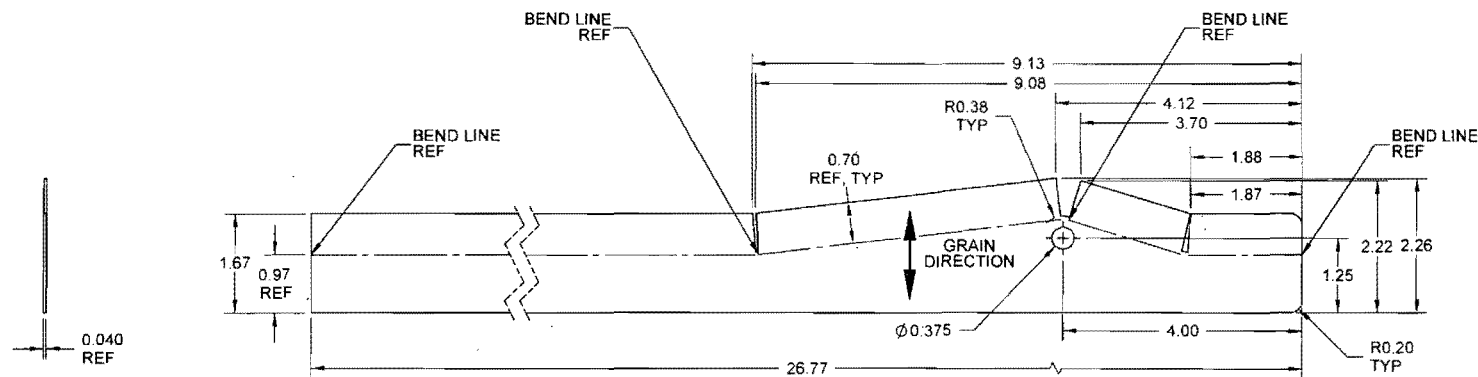
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

WLO 47724



D4005-13F FLAT PATTERN

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4005	SHEET 15 OF 15
APPROVED		TITLE	SCALE
DE APPR.		RESTRAINT	NTS
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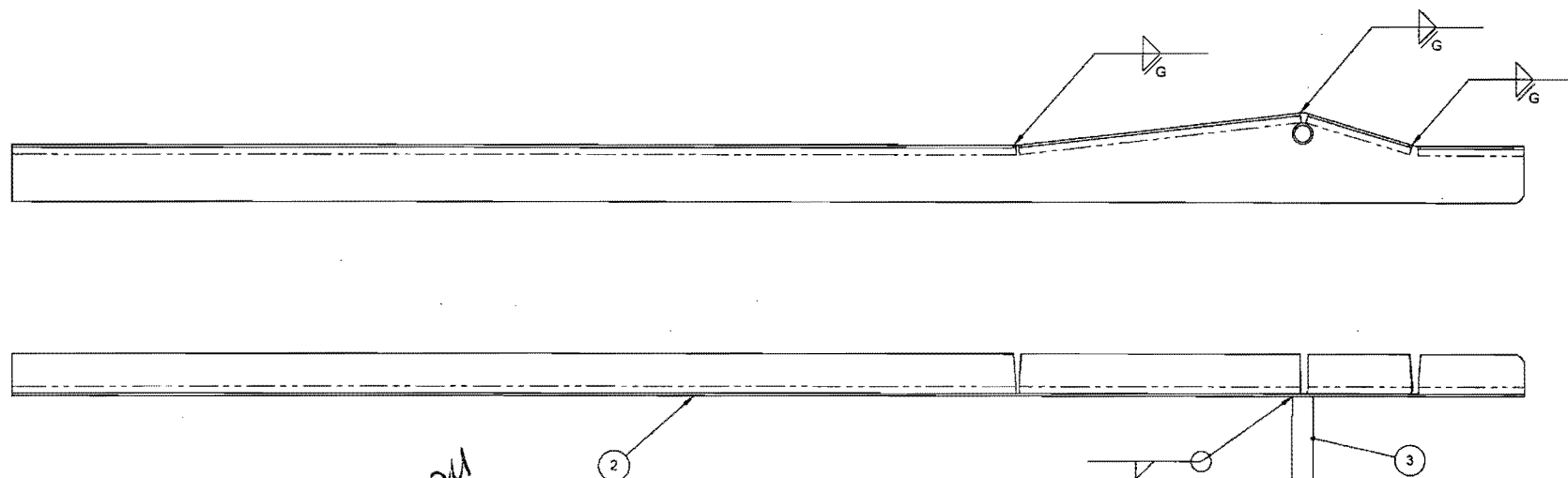
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4005-041	FORWARD FLOOR GUTTER	JCA-M47-2-22
2	1	D4005-13	ANGLE	
3	1	D4003-13	TUBE	



D4005-041 FORWARD FLOOR GUTTER

RELEASED
R 2010-05-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAT QSI 005 4.2
POWDER COAT "GREY SANDTEX" (4.3 5.6) PER DAT QSI 005 4.3
- 3) TOLERANCES: PER DAT QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.22 lbs
- 8) WELD PER DAT QSI 004

A	NEW ISSUE		10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

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Dart Aerospace Ltd

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